

Date: Friday, 5/25/2007 8:36:45 AM
User: Kim Johnston

Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32646 -4
Estimate Number : 12883
P.O. Number : N/A
This Issue : 5/25/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : N/A
Written By :
Checked & Approved By : JH 07.05.25
Comment : Est Rev:A New Issue 07.05.24 EC

Drawing Name : ARM

EFFECTIVE 07.06.05 AUTH

RELEASED 07.06.06 DATE

Part Number : D3560043
Drawing Number : D3560 REV.B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 6/5/2007

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar 50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total : 40.7925 f(s) x 20
6061-T6 Bar 0.50" x 5.00"

Batch: 17625 x 30 x 5 MK4598 X 7

BC 07.06.01

20

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks 15.500" long

BC 07.06.01

20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: B

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

JL/BC 07.06.01

20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/BC 07.06.01

20

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

QML 07/06/10

20

Date: Wednesday, 15/08/2007 7:40:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32646

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

PLATE ~~32646~~ 3 32661

16 07.08.20

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

16 07.08.20

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/11/01 ~~16 07.08.20~~ 16

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

16 07.10.01 16

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32646

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0

QC21

FINAL INSPECTION/W/O RELEASE

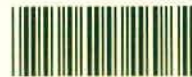


Comment: FINAL INSPECTION/W/O RELEASE

16.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

Job Completion

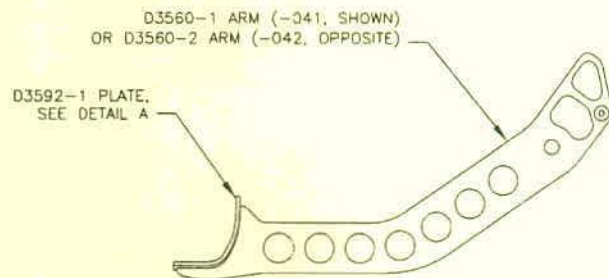


W 07-10-02

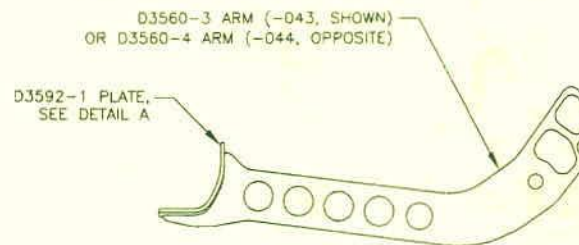
Used for Loshing

00189

12 07-10-01

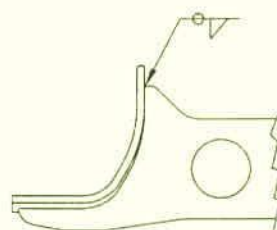
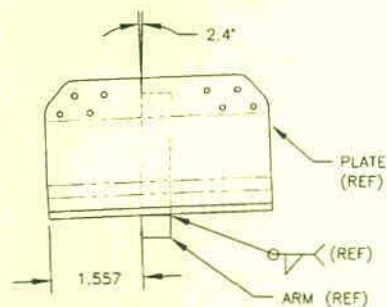


D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)

W/O 3264K



DETAIL A
(SCALE 1:1)

GENERAL NOTES

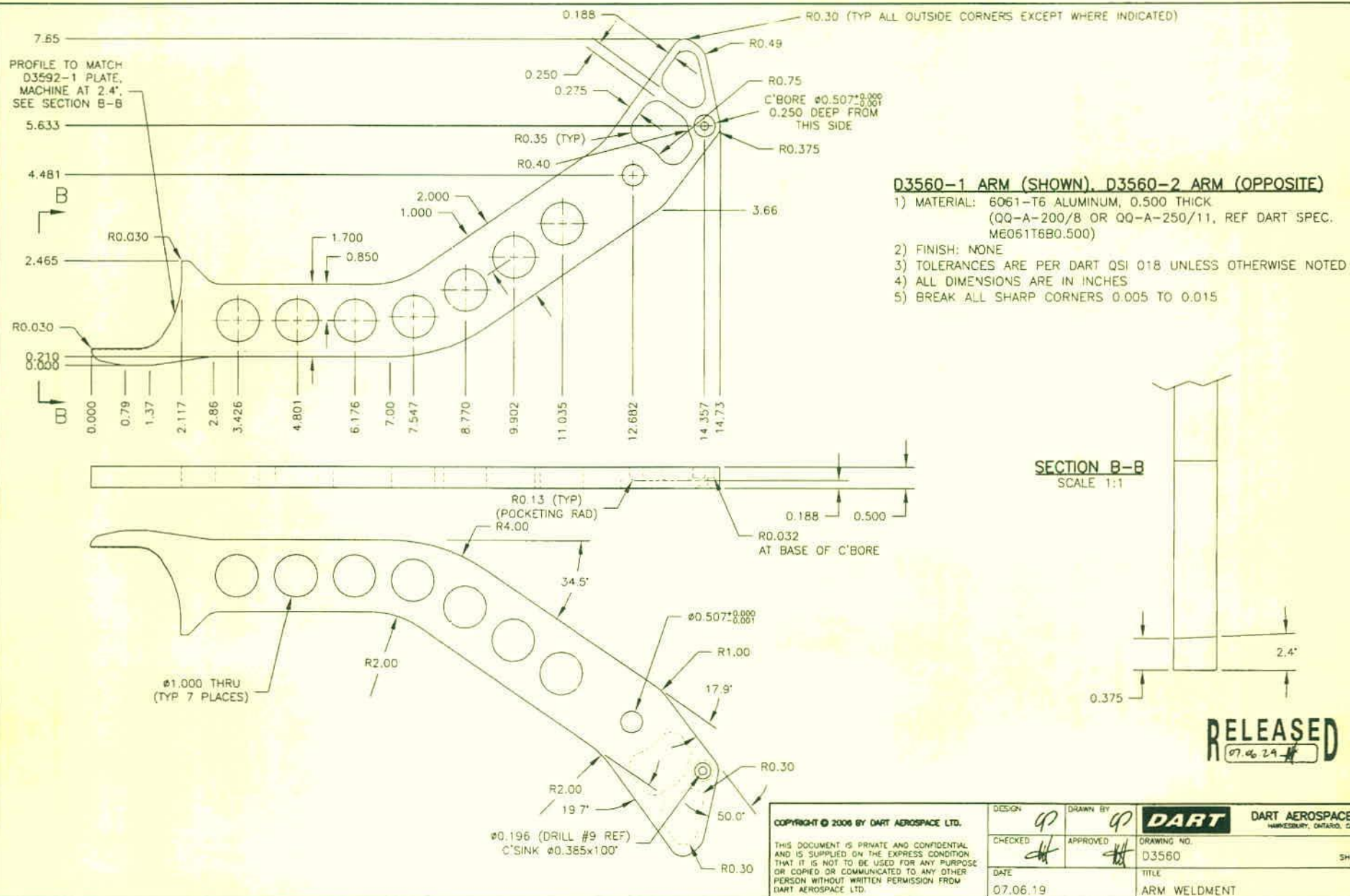
- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

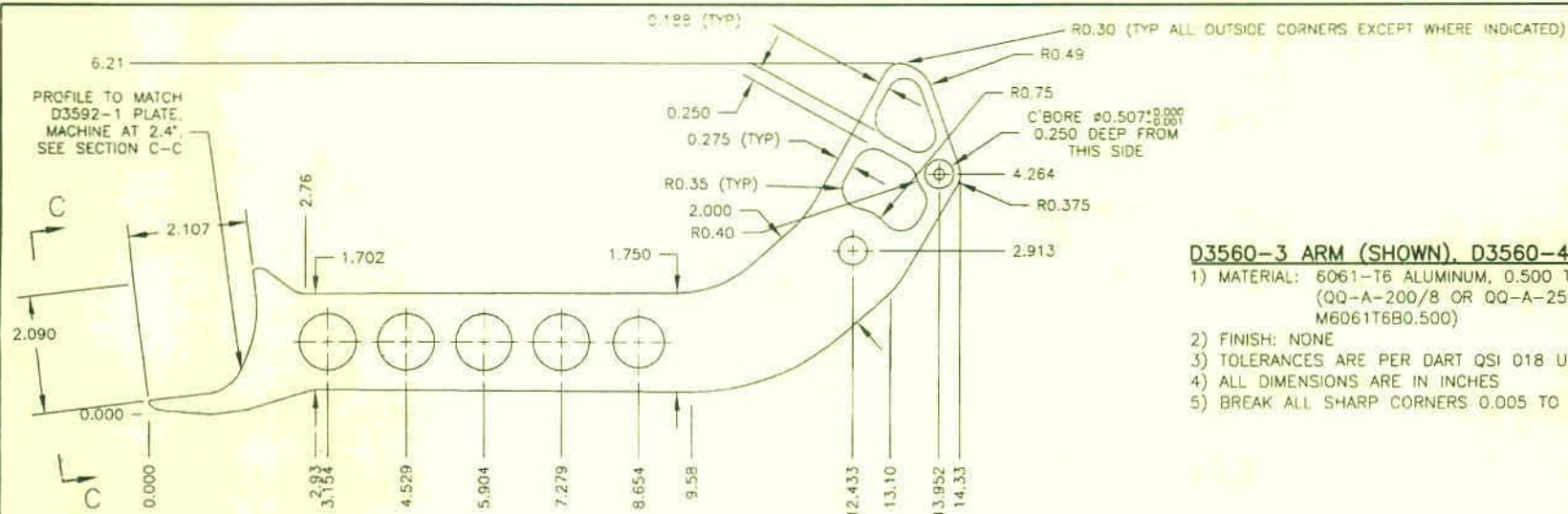
RELEASED
07.06.19

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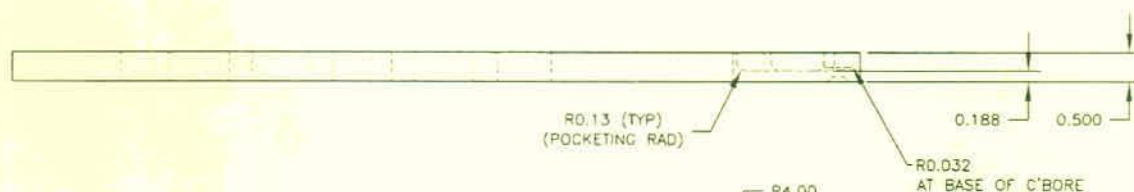
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	TITLE	SHEET 1 OF 3 SCALE
07.06.19	ARM WELDMENT	1:4



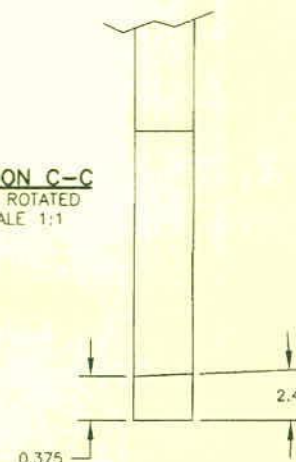


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC, M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



RELEASED
07.06.19

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DESIGN	49	DRAWN BY	49	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	49	APPROVED	49	DRAWING NO.	REV. C
DATE	07.06.19	TITLE	ARM WELDMENT	D3560	SHEET 3 OF 3
		SCALE	1:2		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070822	7-0	Qty 6 parts have cracks on the D3592-1 plate, due to too much heat transfer to gain deeper penetration, during welding. RC: Too hot of a weld on the plate. Employee error.	<i>[Signature]</i>	Remove the D3592-1 plate from the prn, and grind pny access weld flush. Verify prn by Q.C.	<i>[Signature]</i> 07.08.23 a.m. →	<i>[Signature]</i>	<i>[Signature]</i>	070822
↓	↓	↓	<i>[Signature]</i>	Pick new D3592-1 B.32661 weld plates as per Dwg, with normal heat. Scrap & destroy.	<i>[Signature]</i> 07.08.23 <i>[Signature]</i> 07.08.23	<i>[Signature]</i>	<i>[Signature]</i>	070822

NOTE: Date & initial all entries

